



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3912-1
Job Sheet 180874



Part No: D3912-1

Job Qty: 12 ea

Part Name: Eyebolt



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 8/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP RevA: New issue DD verified by:EC

Ship Via:

Handwritten: 10M

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	8/7/18	8/7/18	0.00	0.00	Start Up Machining-2		
100	Doosan	12 pcs	8/7/18	8/7/18	0.00	8.57	Doosan		
110	QC	12 pcs	8/7/18	8/7/18	0.00	0.00	QC2 Machining-2		
120	QC	12 pcs	8/7/18	8/7/18	0.00	0.00	QC8 Machining-2		
130	Packaging	12 pcs	8/7/18	8/7/18	0.00	0.00	Packaging3-2		
140	QC21-SA	12 Ea	8/7/18	8/7/18	0.00	0.00	QC21		

Part Op Descriptions: 100 - TURN AS PER FOLIO FA871AND DWG Prog Rev: _____ Deburr as required

Handwritten: DAS 21 9-89
Stamp: AUG 23 2018
Stamp: AUG 24 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	3,3600 ft (.28 ea)	90-Start up Operation	

Handwritten: 233

Handwritten: 50806

Handwritten: 486

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R2.000	3	36	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eyebolt	0.130Inches ± 0.030	0.160 0.100	<i>Handwritten: .129</i>	
2	Eyebolt	0.700Inches ± 0.010	0.710 0.690	<i>Handwritten: .699</i>	
3	Eyebolt	0.500Inches ± 0.010	0.510 0.490	<i>Handwritten: .500</i>	
4	Eyebolt	0.900Inches ± 0.030	0.930 0.870	<i>Handwritten: .93</i>	
5	Eyebolt	0.130Inches ± 0.030	0.160 0.100	<i>Handwritten: .135</i>	
6	Eyebolt	45.0Degrees ± 0.5	45.5 44.5	<i>Handwritten: 45</i>	
7	Eyebolt	0.220Inches ± 0.030	0.250 0.190	<i>Handwritten: .22</i>	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					

8	Eyebolt	0.750Inches ± 0.030	0.780 0.720	1.758
9	Eyebolt	0.970Inches ± 0.010	0.980 0.960	1.975 1.975
10	Eyebolt	1.720Inches ± 0.030	1.750 1.690	1.72
11	Eyebolt	1.200Inches ± 0.030	1.230 1.170	1.199
12	Eyebolt	0.6250Inches ± 0.0100	0.6350 0.6150	0.625 0.625
13	Eyebolt	2.230Inches ± 0.030	2.260 2.200	2.228
14	Eyebolt	0.130Inches ± 0.030	0.160 0.100	0.125 Radius
15	Eyebolt	0.015Inches ± 0.010	0.025 0.005	0.015 Radius
16	Eyebolt	0.625Inches ± 0.010	0.635 0.615	0.625
17	Eyebolt	0.650Inches ± 0.010	0.660 0.640	0.6475
18	Eyebolt	1.100Inches ± 0.010	1.110 1.090	1.101
19	Eyebolt	0.440Inches ± 0.030	0.470 0.410	0.44
20	Eyebolt	0.130Inches ± 0.030	0.160 0.100	0.125 Radius
21	Eyebolt	1.000Inches ± 0.030	1.030 0.970	1.002
22	Eyebolt	0.250Inches ± 0.030	0.280 0.220	0.249
23	Eyebolt	0.880Inches ± 0.030	0.910 0.850	0.879
24	Eyebolt	0.110Inches ± 0.030	0.140 0.080	0.110
25	Eyebolt	0.719Inches + 0.010 - 0.000	0.729 0.719	0.726

Plex 7/17/18 1:18 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____ Step #: _____ QTY Effective : _____ Approval: _____

Description Work Order Deviation

Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
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www.dartaerospace.com



Container No: S104177

Part: D3912-1

Job No: 180874

Serial No/Batch: S104177

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: Various STC's

Date: 08/22/18

Root Cause			Pressure/Forced		Incomplete/unqualified		Wrong Stock Pulled		Part Incorrect	
Environment ☐	☐	No Re-verification ☐	☐	Bending ☐	☐	Contamination ☐	☐	Out of Sequence ☐	☐	Part Lost/Missing ☐
Design ☐	☐	Operator ☐	☐	Centre Not Concentric ☐	☐	Countersink ☐	☐	Off-set ☐	☐	Part Moved ☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Cracks ☐	☐	Cut Too Short ☐	☐	Mislabeled ☐	☐	Drawing ☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Instructions Incomplete/Unclear ☐	☐	Fit/Function ☐	☐	Finish ☐
Handling/Pre ☐	☐	Training ☐	☐	Cuffs ☐	☐	Drill Holes ☐	☐	Misaligned/off center ☐	☐	Misread ☐
Material ☐	☐	Use for Testing ☐	☐	Crushing ☐	☐					Turning Sequence ☐
Internal Transport ☐	☐	Poor Information ☐	☐	Heat Treat ☐	☐					
Tribal Knowledge ☐	☐	Rushing ☐	☐	Wave/Twist in Tube ☐	☐					
LOA ☐	☐	Product Improvement ☐	☐	Marks/Chatter ☐	☐					
Substation ☐	☐	Process Improvement ☐	☐		☐					
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐							
Misidentified ☐	☐	Past Due ☐	☐	OTHER : _____						